

Work Order ID 77274

77274

Page 1

Item ID: D2966-1-BENT

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube Assembly 105

Stop ***NS2***

Start Date: 01/12/2011 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 14/12/2011 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/12/10 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2966	Rev A

120

120

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

Bend tube as per program BO105 on CNC Bender and Dwg D2966. Bend folio #1 use bending aid DT9631

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

300

300

Packaging

Packaging

Identify as per dwg & Stock Location: 46 0.00
Packaging

Memo

0.00

SCRAP

DC 12/02/22 PTC

DD 12-2-22

DD 12-2-22

W/O: 77274		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2966-1-BENT PAR #: _____ Fault Category: San. Tab NCR: Yes No DQA: Not Date: 12/2/21
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 12/2/21

NCR: 12-1230		WORK ORDER NON-CONFORMANCE (NCR) # 1158						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-2-22	120	Tube crushed while Bending 1"00 deep. QTY-1 RC process	h 12-02-23 QSI 042	Scrap.	DL 12/02/22	DP 12-2-22	le 12-02-23 QSI 042	mta/ 12-02-23

NOTE: Date & initial all entries

Work Order ID 77274***77274***

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December-01-11 9:21:00 AM

Item ID: D2966-1-BENT

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube Assembly 105

Stop ***NS2***

Start Date: 01/12/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 14/12/2011 Req'd Qty: 2.00

2

Customer:

Reference:

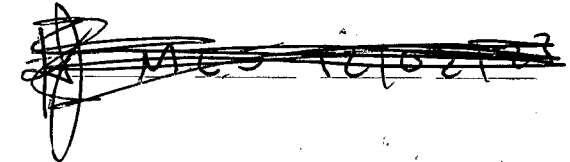
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.00							
Quality Control									



12/20/23
P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-01-11 9:21:04 AM

Page 1

Work Order ID: 77274

77274

Parent Item: D2966-1-BENT

D2966-1-BFNT

Parent Item Name: Skidtube Assembly 105

Start Date: 01/12/2011

Required Date: 14/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.09.17 New issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2962-125		Manufactured	No				Each	23.0000		2			
D2962-125									**				
Outer Tube Extrusion													

12/02/22

Location

Loc Qty

Loc Code

HALL

23

17532

23

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2966	REV. A SHEET 1 OF 2
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY	SCALE NTS
A	00.03.08	NEW ISSUE	

RELEASED
00.05.11 #

Qty	Part Number	Description
X	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE
1	D2971	CROSS BOLT SPACER
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130	INSERT
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
1	D3176-1	BUSHING
1	D3176-3	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77274

M.C.S
11/18/01



GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:

ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.4) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART
QSI 005 4.4 (OPTIONAL) BLACK SANDTEX (REF 4.3.5.7)



01.01.29
IP 01.01.30

A2	02.10.30	ADD D3176-1/-3	# IP
A1	01.01.29	CHANGE COLOR TO BLACK SANDTEX	# IP

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

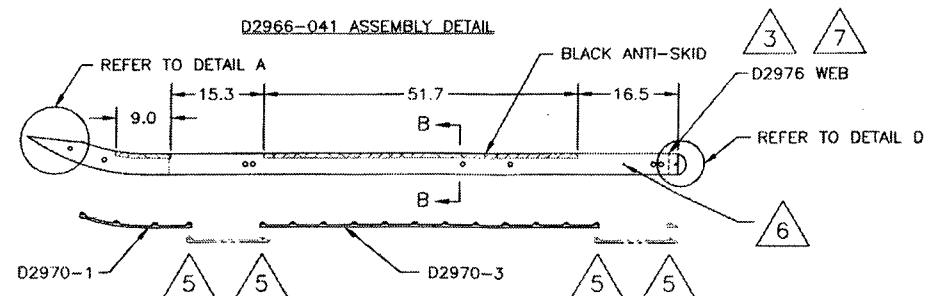
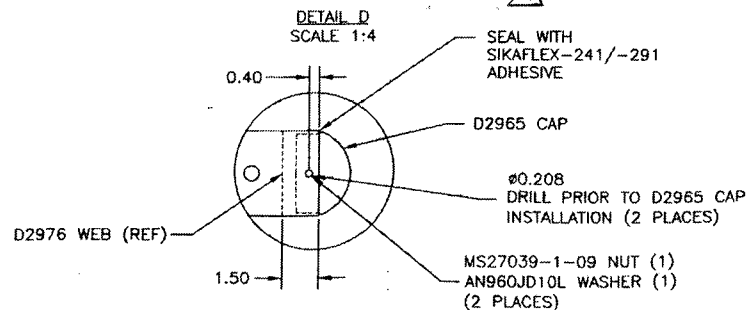
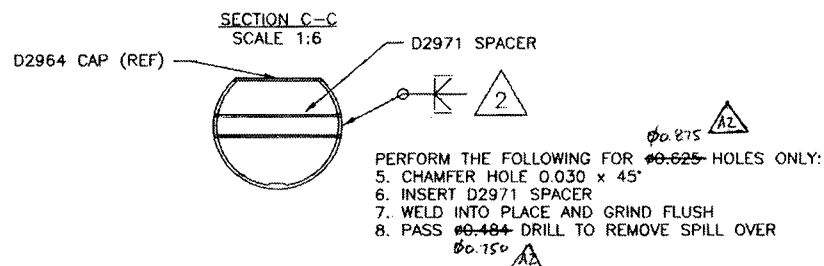
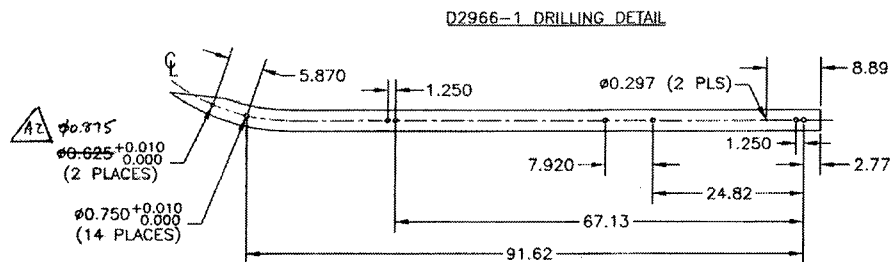
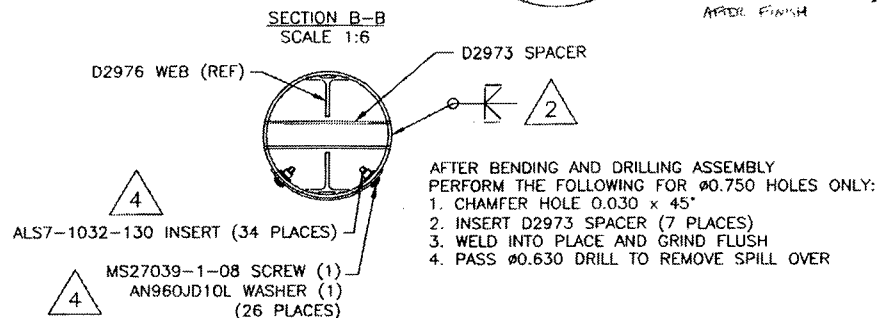
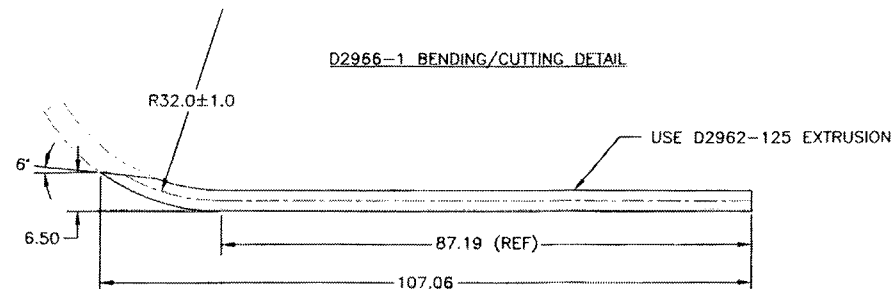
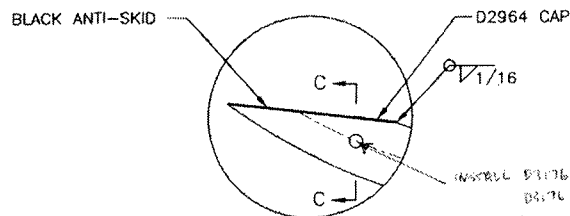
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____


Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A
SCALE 1:3



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DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY		SCALE 1:20	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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